

(19) Europäisches Patentamt

European Patent Office

Office européen des brevets



(11) EP 0 819 501 A1

(12)

## EUROPEAN PATENT APPLICATION

(43) Date of publication:  
21.01.1998 Bulletin 1998/04

(51) Int. Cl.<sup>6</sup>: B25B 5/06

(21) Application number: 97201996.2

(22) Date of filing: 01.07.1997

(84) Designated Contracting States:  
AT BE CH DE DK ES FI FR GB GR IE IT LI LU MC  
NL PT SE

(30) Priority: 19.07.1996 JP 190481/96

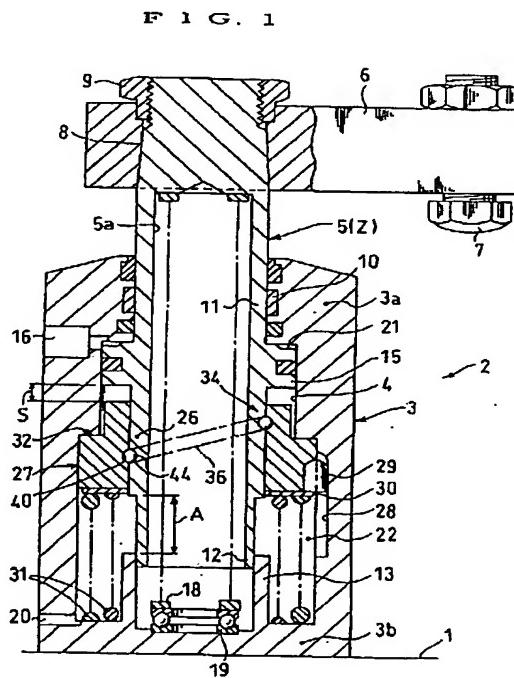
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### (54) Rotary Clamping apparatus

(57) An upper end wall (3a) and a lower end wall (3b) of a housing (3) are adapted to support an upper sliding portion (11) and a lower sliding portion (12) of a clamp rod (5), respectively. A rotary portion (26) is provided on the clamp rod (5) below a piston (15) fixed to the clamp rod (5). A rotation actuating sleeve (27) is externally fitted onto the rotary portion (26) axially movably but unrotatably. The sleeve (27) is urged upward by a pushing spring (31) and prevented from moving farther than a predetermined distance by a stopper (32). An axial movement of the clamp rod (5) is converted to a rotary movement by a converting mechanism (34).



**Description****BACKGROUND OF THE INVENTION****Technical Field**

This invention relates to a clamping apparatus of the type which linearly moves a clamp rod to a clamping position after having rotated it from a retreated position to an unclamping position.

**Explanation of Earlier Technology**

Conventionally, there has been existing a clamping apparatus disclosed in Japanese Utility Model Publication No. 60-18267 as an example of the rotary clamping apparatus of this type.

More specifically, it is a clamping apparatus which comprises a housing provided with an upper end wall slidably supporting a clamp rod, a rotation actuating shaft being inserted into a lower portion of the clamp rod, an engaging pin fixed onto the clamp rod being engaged with a guide groove of the shaft. The clamp rod is rotated along an inclined cam portion of the guide groove and thereafter moved to a clamping position along a linear portion of the guide groove.

The above-mentioned conventional technique requires a predetermined engaging gap between the engaging pin and the guide groove and therefore cannot guide the clamp rod straightly. Accordingly, it encounters a difficulty in linearly driving the clamp rod with accuracy at the time of clamping.

**SUMMARY OF THE INVENTION**

An object of the present invention is to improve the linearity of the clamp rod at the time of clamping.

In order to accomplish the above object, the invention of claim 1 has constructed a rotary clamping apparatus as follows, for example, as shown in Figs. 1 to 9.

A clamp rod 5 is inserted into a guide bore 4 within a housing 3. A first end wall 3a of the housing 3 is adapted to slidably support a first sliding portion 11 of the clamp rod 5 and a second end wall 3b of the housing 3 is adapted to slidably support a second sliding portion 12 of the clamp rod 5. A piston 15 is provided on the clamp rod 5 between the first sliding portion 11 and the second sliding portion 12 and axially movably inserted into the guide bore 4. A rotary portion 26 is provided on the clamp rod 5 between the piston 15 and the second sliding portion 12. A rotation actuating sleeve 27 is inserted axially movably into an annular space between the rotary portion 26 and the guide bore 4 with its rotation stopped. The sleeve 27 is urged toward the first end wall 3a by a pushing spring 31. A stopper means 32 is provided for preventing the sleeve 27 from moving farther than a predetermined distance. A converting mechanism 34 for converting an axial movement of the clamp

rod 5 to a rotary movement is provided extending over the rotary portion 26 and the sleeve 27.

The invention of claim 1 presents the following advantage.

A first end wall of a housing supports a first sliding portion of a clamp rod and a second end wall of the housing supports a second sliding portion of the clamp rod. A rotation actuating sleeve is externally fitted onto a rotary portion provided between these two sliding portions. Therefore, the clamp rod can be guided precisely at two positions, namely the first and the second sliding portions, independently of an engaging gap to be required for the rotary portion and the sleeve and besides the distance between the two sliding portions is large. This can increase the effective guide length of the clamp rod and improve the linearity at the time of clamping operation to thereby perform the clamping accurately.

**20 BRIEF DESCRIPTION OF THE DRAWINGS**

Figs. 1 to 9 show one embodiment of a clamping apparatus according to the present invention;

- 25 Fig. 1 is a vertical sectional view of the clamping apparatus retreated;
- Fig. 2 is a vertical sectional view of the clamping apparatus unclamped;
- Fig. 3 is a vertical sectional view of the clamping apparatus clamped;
- Fig. 4 is a plan view of Fig. 1;
- Fig. 5 is an elevational view of a rotary portion provided on a clamp rod of the clamping apparatus;
- Fig. 6(A) is a plan view of a sleeve to be externally fitted onto the rotary portion;
- Fig. 6(B) is a sectional view taken along a line B-B in Fig. 6(A) when seen in a direction indicated by arrows;
- Fig. 7 is a developed view of the sleeve when cutting it along a line VII in Fig. 6(A) and seeing the cut surface from the inside;
- Fig. 8 is a developed view of the rotary portion and corresponds to Fig. 7;
- Fig. 9(A) is a view explaining the operation of the sleeve and the rotary portion and showing the clamp rod switched over to a retreated position; and
- Fig. 9(B) shows the clamp rod switched over to an unclamping position.

**50 DESCRIPTION OF THE PREFERRED EMBODIMENTS**

Hereafter, one embodiment of the present invention will be explained with reference to Figs. 1 through 9.

First, a clamping apparatus is outlined with reference to Figs. 1 and 4. Fig. 1 is a vertical sectional view showing the clamping apparatus retreated. Fig. 4 is a plan view of Fig. 1.

A plurality of bolts (not shown) fix a housing 3 of a clamping apparatus 2 to a table 1 for a machine tool. Inserted into a guide bore 4 within the housing 3 is a cylindrical clamp rod 5 which has an arm 6 radially projecting from its upper end portion (a first end portion). The arm 6 is provided with a push bolt (pushing member) 7 at its leading end. The arm 6 is engaged with a tapered surface 8 of the clamp rod 5 to be fixed at a predetermined rotation position through a nut 9.

A guiding bush 10 is attached to an upper end wall (a first end wall) 3a of the housing 3. The bush 10 slidably supports an upper sliding portion (a first sliding portion) 11 of the clamp rod 5. Further, the housing 3 is provided at its lower end wall (a second end wall) 3b with a guide cylinder 13. The guide cylinder 13 slidably supports a lower sliding portion (a second sliding portion) 12 of the clamp rod 5.

A piston 15 is provided on the clamp rod 5 between the upper sliding portion 11 and the lower sliding portion 12. The piston 15 is axially movably and hermetically inserted into the guide bore 4. Although the piston 15 is integrally formed with the clamp rod 5, it may be separately formed therefrom.

A first chamber 21 for clamping is formed between the upper end wall 3a and the piston 15. Pressurized oil (pressurized fluid) is adjusted to be able to be supplied to and discharged from the first chamber 21 through a supply and discharge port 16. Additionally, a second chamber 22 for unclamping is formed between the lower end wall 3b and the piston 15. An unclamping spring 18 attached within the second chamber 22 urges the clamp rod 5 upwards. More specifically, the unclamping spring 18 is inserted into a hollow portion 5a of the clamp rod 5 to bring its upper end into contact with an upper portion of the clamp rod 5 and have its lower end received by a thrust bearing 19. The second chamber 22 is communicated with the atmosphere through a breather passage 20.

A rotary portion 26 is provided on the clamp rod 5 between the piston 15 and the lower sliding portion 12. Further, a rotation actuating sleeve 27 is axially movably inserted into an annular space between the rotary portion 26 and the guide bore 4 with its rotation stopped. More concretely, a detent pin 29 is interposed between a vertical groove 28 formed in the guide bore 4 and the sleeve 27. A support plate 30 prevents the detent pin 29 from dropping. The vertical groove 28 and the pin 29 compose a means for linearly guiding the sleeve 27 in a vertical direction.

The sleeve 27 is urged upward by a pushing spring 31 composed of two coil springs and prevented from moving upwards farther than a predetermined distance by a stopper 32 constructed from a stepped portion of the guide bore 4. The value of the urging force of the pushing spring 31 is set to substantially the same as that of the urging force of the unclamping spring 18.

A converting mechanism 34 is provided extending over the rotary portion 26 and the sleeve 27. The con-

verting mechanism 34 converts an axial movement of the clamp rod 5 to a rotary movement, although its concrete structure is explained later.

Operation of the clamping apparatus is explained with reference to Figs. 1, 2 and 3. In Figs. 1 to 3, characters (A), (B) and (S) indicate a whole stroke, a clamping stroke and a rotation stroke, respectively.

On switching over from a retreated condition of Fig. 1 to a clamping condition of Fig. 3 via an unclamping condition of Fig. 2, pressurized oil is first supplied to the first chamber 21 for clamping in the retreated condition of Fig. 1.

Then the piston 15 goes down and the clamp rod 5 lowers while being rotated by the converting mechanism 34. And as shown in Fig. 2, when the piston 15 goes down by the rotation stroke (S) to contact with the sleeve 27, the clamp rod 5 is switched over to an unclamping position (Y). Next, the piston 15 lowers the sleeve 27 against the pushing spring 31 by oil pressure force of the first chamber 21 and as a result the clamp rod 5 is switched over to a clamping position (X) of Fig. 3.

On switching over from the clamping condition of Fig. 3 to the retreated condition of Fig. 1 via the unclamping condition of Fig. 2, the pressurized oil in the first chamber 21 is discharged in the clamping condition of Fig. 3.

Then the clamp rod 5 and the sleeve 27 go upwards by the urging force of the unclamping spring 18 and that of the pushing spring 31. And as shown in Fig. 2, the sleeve 27 goes upwards by the clamping stroke (B) to be received by the stopper 32, thereby switching over the clamp rod 5 to the unclamping position (Y).

Subsequently, the clamp rod 5 goes upwards by the rotation stroke (S) while being rotated by the urging force of the unclamping spring 18 and is switched over to a retreated position (Z) of Fig. 1.

Next, a concrete structure of the converting mechanism 34 is explained with reference to Figs. 5 through 8. Fig. 5 is an elevational view of the rotary portion 26 provided on the clamp rod 5. Fig. 6(A) is a plan view of the sleeve 27 and Fig. 6(B) is a sectional view taken along a line B-B in Fig. 6(A) when seen in a direction indicated by arrows. Fig. 7 is a developed view of the sleeve 27 when cutting it along a line VII in Fig. 6(A) and seeing the cut surface from the inside. Fig. 8 is a developed view of the rotary portion 26 and corresponds to Fig. 7.

As shown in Figs. 5 and 8, the rotary portion 26 is provided with a rotary groove 36 concaved in the shape of an arc. The rotary groove 36 is composed of a first groove portion 37 formed spirally only by about one pitch in an outer peripheral surface of the rotary portion 26 and a second groove portion 38 communicating an initial end of the first groove portion 37 with a terminal end thereof substantially in an axial direction.

As shown in Figs. 6(A) and 6(B), and Fig. 7, the sleeve 27 is provided with an actuating groove 40. The actuating groove 40 is composed of a rotation actuating

groove portion 41 formed spirally in correspondence with the first groove portion 37 and a relief groove portion 42 formed so as to peripherally extend in correspondence with the second groove portion 38. As shown in Fig. 6(A), a peripheral length of the relief groove portion 42 is adjusted to correspond to a rotation angle ( $\theta$ ) (about 90 degrees in this embodiment) of the clamp rod 5.

As shown in Fig. 8 (and Fig. 1), a number of steel rolling balls 44 are charged into a space between the rotary groove 36 and the actuating groove 40.

Operation of the converting mechanism 34 of the above structure is explained by Figs. 9(A) and 9(B) with reference to Fig. 8.

In a retreated condition of Fig. 9(A), the clamp rod 5 is raised to the retreated position (Z) shown by an alternate dash-and-two dots chain line relatively to the sleeve 27 and the rotary portion 26 of the clamp rod 5 is rotated in a counter-clockwise direction when seen in a plan view. When the clamp rod 5 is lowered relatively to the sleeve 27, as shown in Fig. 9(B) the rotary portion 26 is lowered along the groove portion 41 while being rotated in a clockwise direction when seen in the plan view and at the same time the balls 44 are circulated in the clockwise direction when seen in the plan view. Thus the clamp rod 5 is switched over to the unclamping position (Y) shown by an alternate dash-and-dot chain line.

The clamp rod 5 is switched over from the unclamping position (Y) of Fig. 9(B) to the retreated position (Z) of Fig. 9(A) according to the procedures substantially reverse to the above-mentioned ones.

The foregoing embodiment has the following advantages.

Since the clamp rod 5 is supported at vertical two positions, namely the upper end wall 3a and the lower end wall 3b of the housing 3, an effective guide length is large. This enhances the linearity at the time of clamping operation to thereby perform the clamping accurately.

In addition, when the push bolt 7 clamps an object to be fixed (not shown) such as a workpiece or the like, a reaction force resulting from the push bolt 7 acts on the clamp rod 5 as an eccentric load via an arm 6. However, having a large effective guide length as mentioned above, the clamp rod 5 can avoid operation failure caused by seizing or the like to thereby move smoothly.

The clamp rod 5 is cylindrically formed to provide a hollow portion 5a and the unclamping spring 18 is inserted into the hollow portion 5a. Therefore, the hollow portion 5a can be utilized as a space for attaching the unclamping spring 18 to result in the possibility of making the housing 3 compact. This makes it possible to downsize the clamping apparatus.

An inner space of the second chamber 22 for unclamping is used as a space for attaching the sleeve 27 and the pushing spring 31, so that the housing 3 can be made more compact. This makes it possible to fur-

ther downsize the clamping apparatus.

The clamp rod 5 can perform the unclamping operation smoothly and assuredly because both the urging force of the unclamping spring 18 and that of the pushing spring 31 act thereon when it is switched over from the clamping position (X) of Fig. 3 to the unclamping position (Y) of Fig. 2.

Further, since any excessive force does not act on the balls 44, only a single set of the rotary groove 36 and the actuating groove 40 is sufficient and besides the number of the required balls is reduced to result in the possibility of making the converting mechanism 34 compact and simple. More concretely, while only the urging force of the pushing spring 31 acts on the balls 44 between the unclamping condition of Fig. 2 and the clamping condition of Fig. 3, merely the urging force of the unclamping spring 18 acts on the balls 44 between the unclamping condition of Fig. 2 and the retreated condition of Fig. 1. In either case, no excessive force acts on the balls 44.

Having a structure of rolling-ball type, the converting mechanism 34 suffers from only a small frictional resistance at the time of rotation. In consequence, it is possible to perform a smooth rotation and at the same time shorten a lead of the rotary groove 36. As a result, the rotation stroke (S) can be reduced, which in turn decrease a vertical space for installing the clamping apparatus 2.

The above embodiment can be modified as follows.

The fluid to be supplied to the first chamber 21 may be other kinds of liquid or a gas such as air instead of the pressurized oil.

The rotation angle ( $\theta$ ) of the clamp rod 5 may be set to any desired angle such as 60 degrees, 45 degrees, 30 degrees or the like instead of the above-mentioned about 90 degrees.

The converting mechanism 34 may have another structure utilizing a cam groove or the like, instead of the illustrated structure of the rolling-ball type.

The means for linearly guiding the sleeve 27 may be formed from a guide bore rectangular in cross section and a sleeve of the same shape fitted to one another, instead of combining the vertical groove 28 of the guide bore 4 with the pin 29.

The clamping apparatus 2 may be of double-acting type instead of the illustrated single-acting type. More specifically, it may be constructed so that the pressurized fluid can be supplied to and discharged from the second chamber 22 as well, and the unclamping spring 18 is omitted.

## Claims

### 1. A rotary clamping apparatus comprising:

a housing (3) having a first end wall (3a) and a second end wall (3b), and a guide bore (4);  
a clamp rod (5) inserted into the guide bore (4),

the clamp rod (5) being provided with a first sliding portion (11) slidably supported by the first end wall (3a) and a second sliding portion (12) slidably supported by the second end wall (3b);

a piston (15) provided on the clamp rod (5) between the first sliding portion (11) and the second sliding portion (12), the piston (15) being axially movably inserted into the guide bore (4);

a rotary portion (26) provided on the clamp rod (5) between the piston (15) and the second sliding portion (12);

a rotation actuating sleeve (27) inserted into an annular space between the rotary portion (26) and the guide bore (4);

a linearly guiding means (28,29) enabling the sleeve (27) to axially move and preventing it from rotating around the axis;

a pushing spring (31) urging the sleeve (27) toward the first end wall (3a);

a stopper means (32) preventing the sleeve (27) from being moved by the pushing spring (31) farther than a predetermined distance; and

a converting mechanism (34) provided extending over the rotary portion (26) and the sleeve (27) so as to convert an axial movement of the clamp rod (5) to a rotary movement.

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2. A clamping apparatus as set forth in claim 1, wherein

the clamp rod (5) is cylindrically formed to provide a hollow portion (5a).

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a first chamber (21) for clamping being formed between the first end wall (3a) of the housing (3) and the piston (15), a pressurized fluid being adjusted to be supplied to and discharged from the first chamber (21),

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a second chamber (22) for unclamping being formed between the second end wall (3b) of the housing (3) and the piston (15), the sleeve (27), the pushing spring (31) and an unclamping spring (18) being arranged in the second chamber (22),

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the unclamping spring (18) being inserted into the hollow portion (5a) of the clamp rod (5), the clamp rod (5) being urged toward the first end wall (3a) by the unclamping spring (18).

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3. A clamping apparatus as set forth in claim 1 or claim 2, wherein a guide cylinder (13) is fixed to the second end wall (3b), the second sliding portion (12) of the clamp rod (5) being supported by the guide cylinder (13).

4. A clamping apparatus as set forth in any one of

claims 1 to 3, wherein the clamp rod (5) has a first end portion provided with a forwardly narrowing tapered surface (8), an arm (6) being fixed to the tapered surface (8) by taper fitting.

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5. A clamping apparatus as set forth in any one of claims 1 to 4, wherein the piston (15) is integrally formed with the clamp rod (5).

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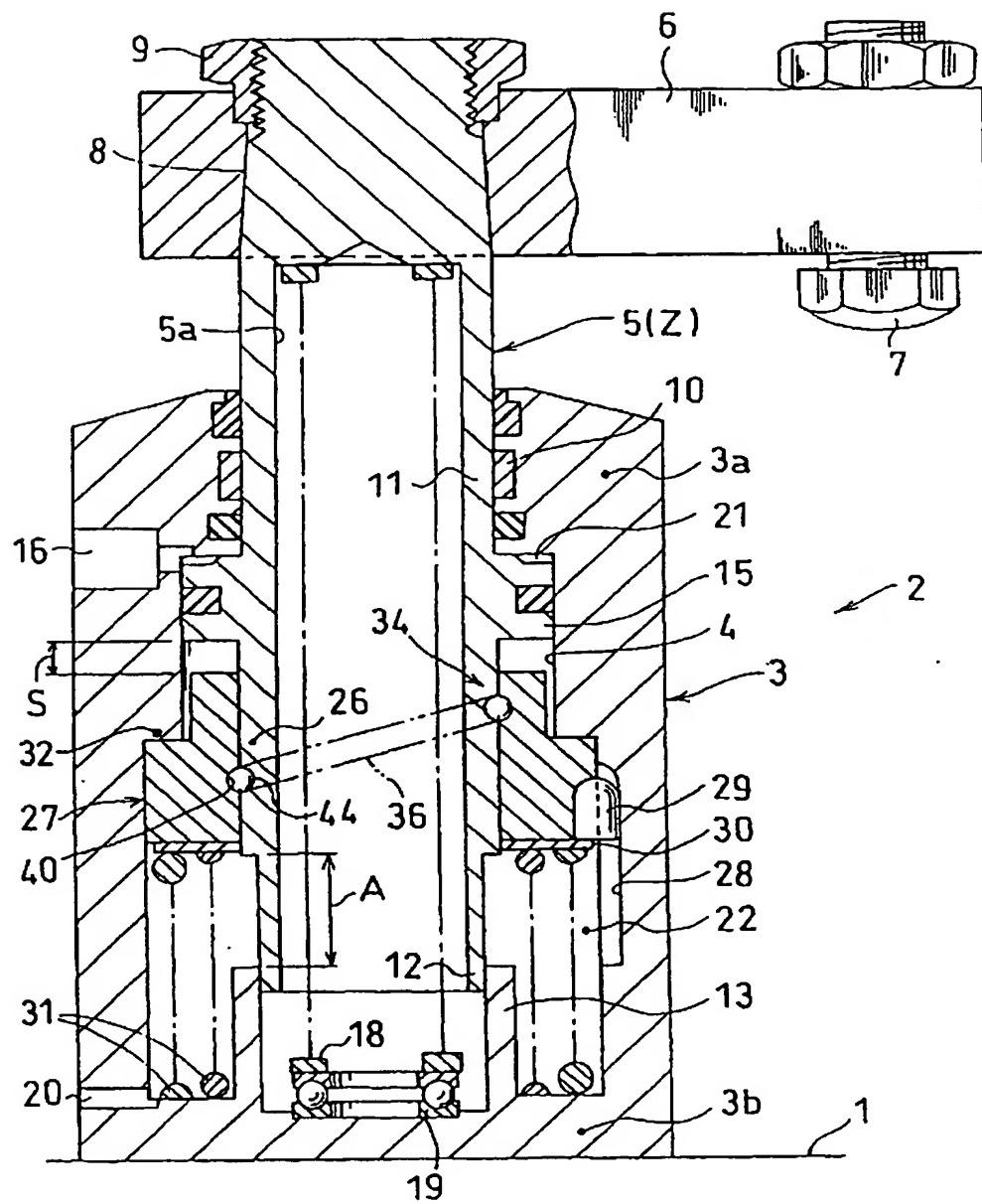
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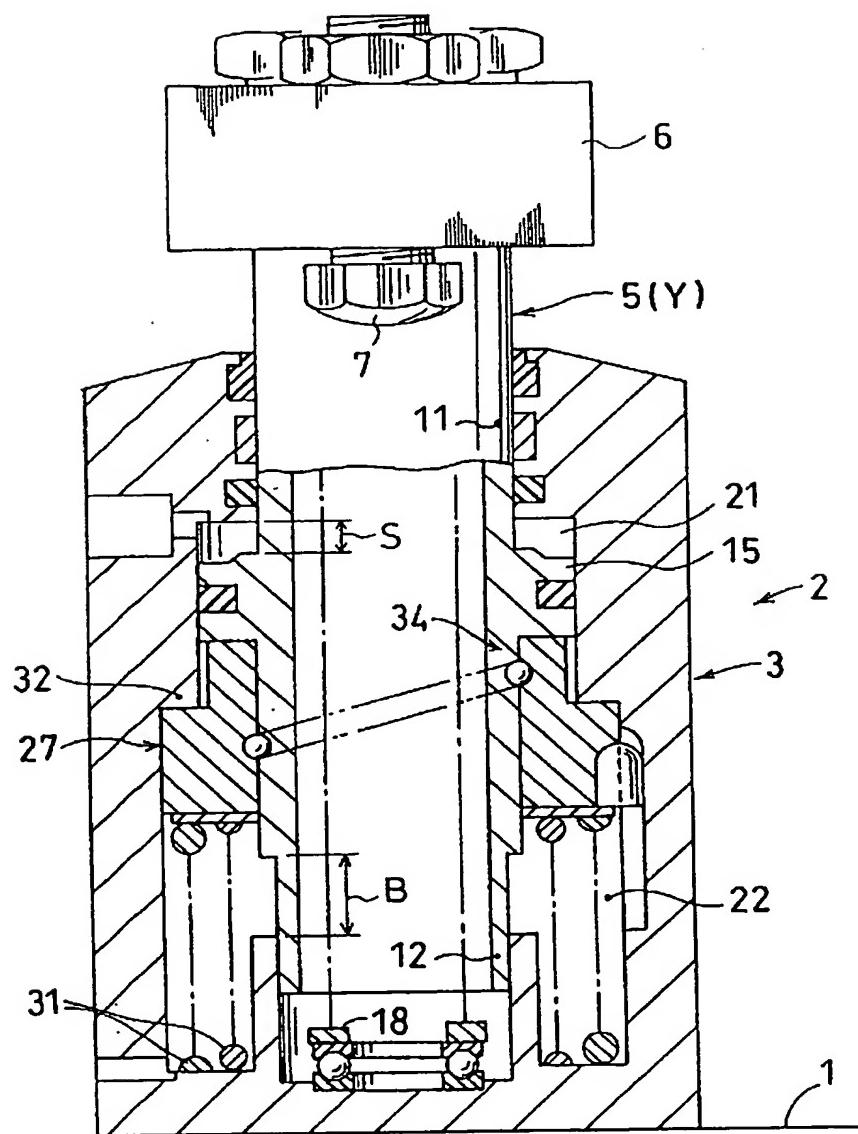
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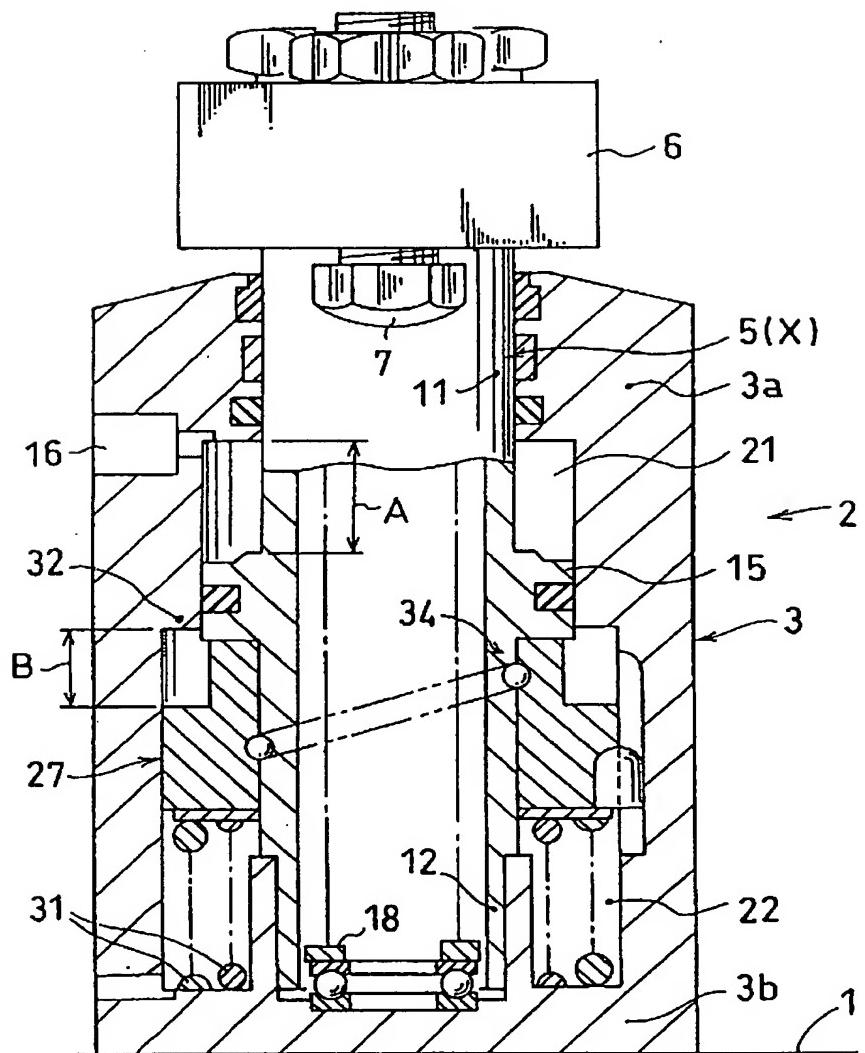
F I G. 1



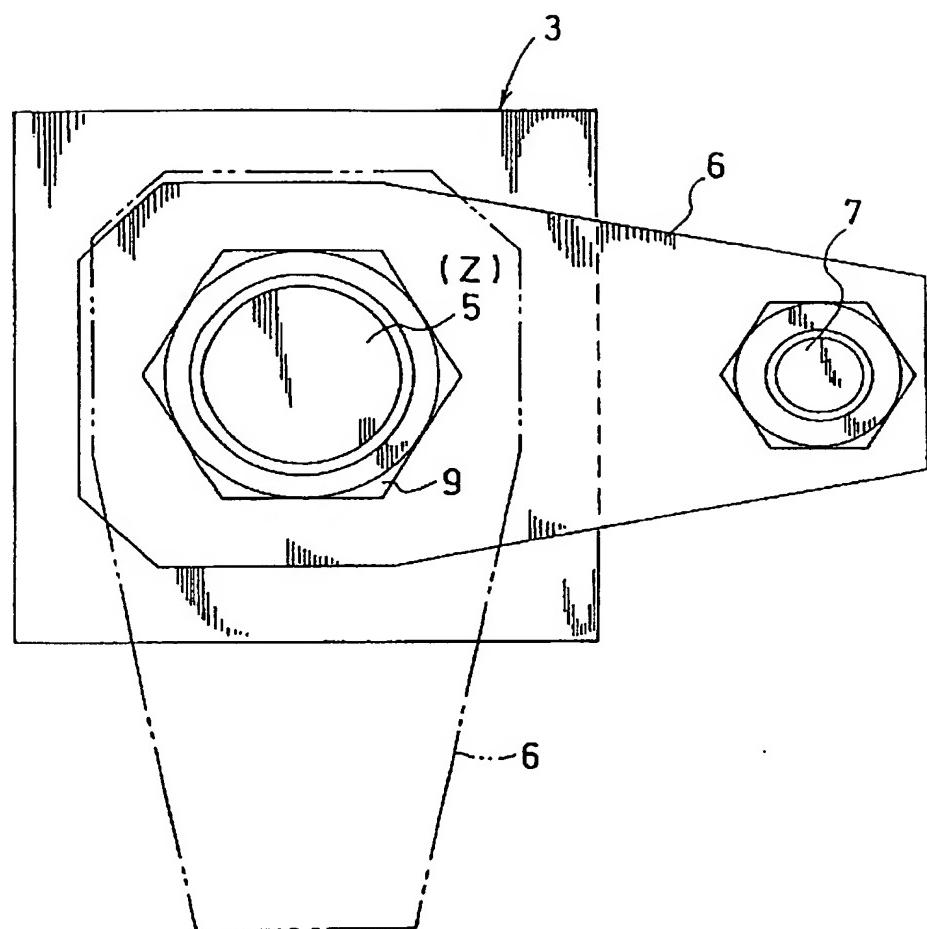
F I G. 2



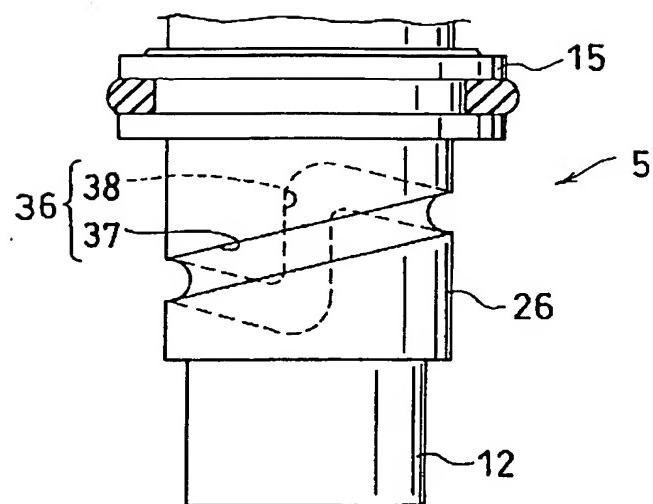
F I G. 3



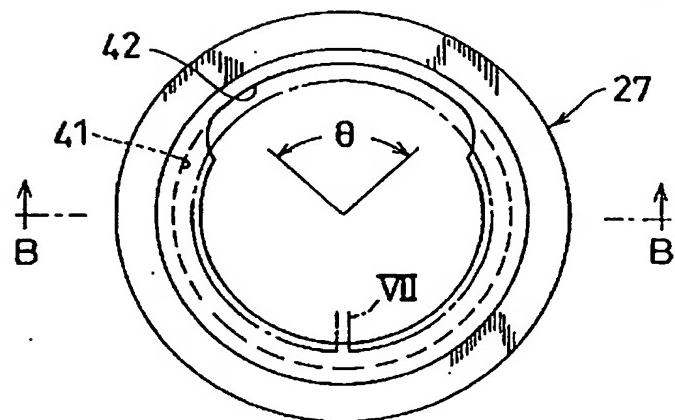
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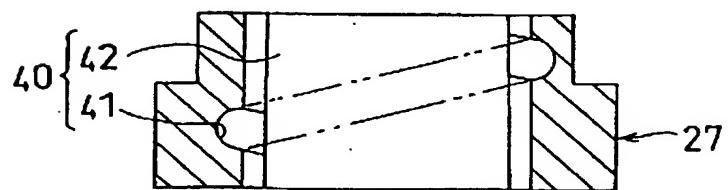
F I G. 5



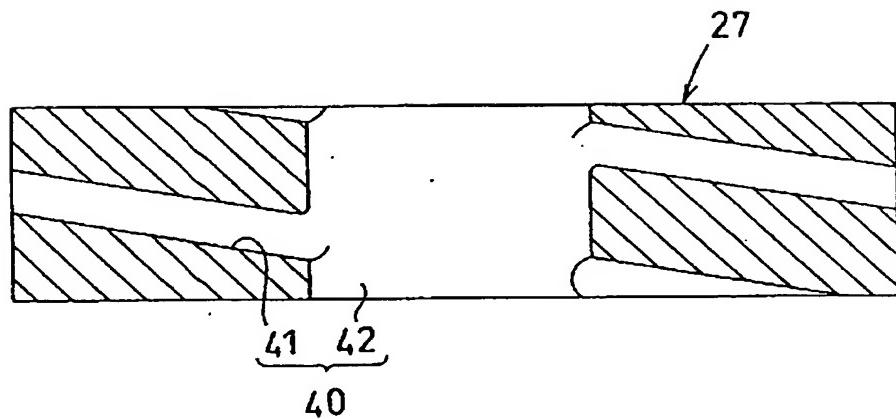
F I G. 6 (A)



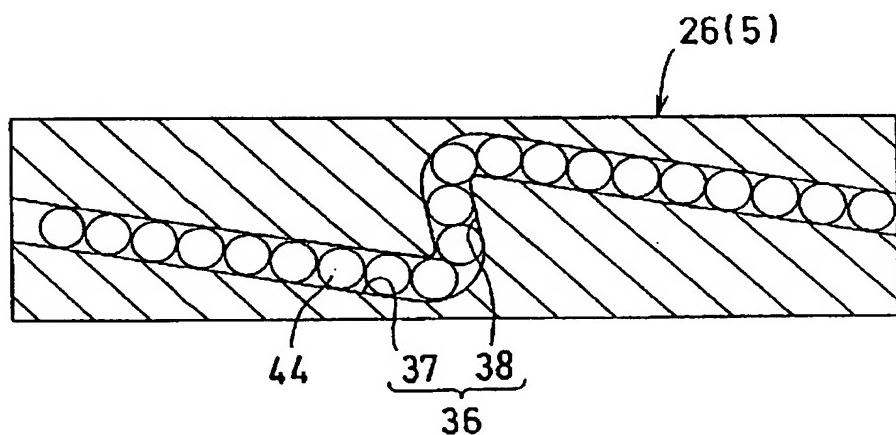
F I G. 6 (B)



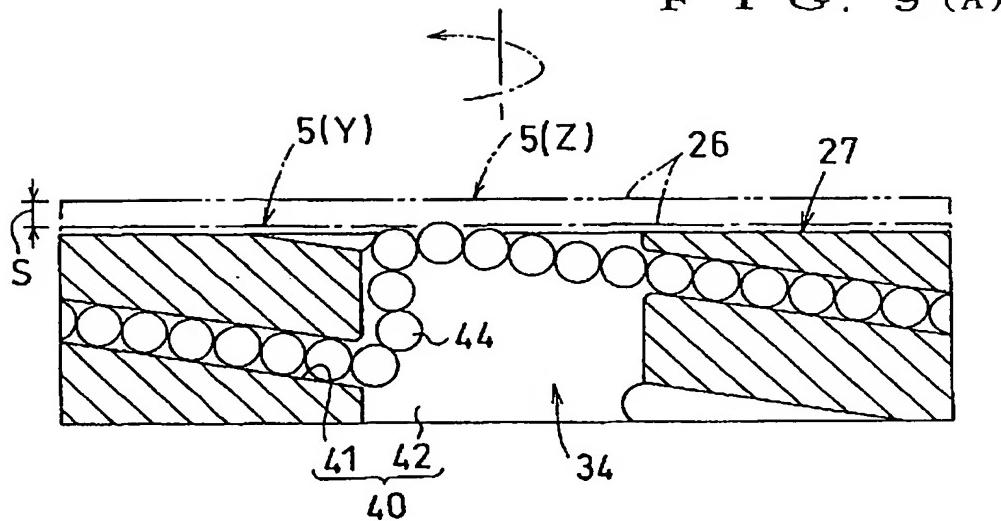
F I G. 7



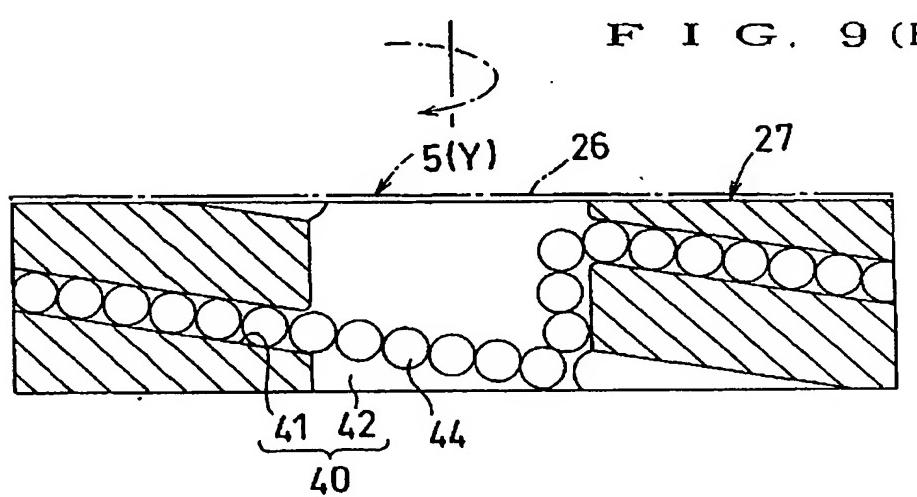
F I G. 8



F I G. 9 (A)



F I G. 9 (B)





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## EUROPEAN SEARCH REPORT

Application Number  
EP 97 20 1996

DOCUMENTS CONSIDERED TO BE RELEVANT			CLASSIFICATION OF THE APPLICATION (Int'l Cls)
Category	Citation of document with indication, where appropriate, of relevant passages	Relevant to claim	
A	GB 1 435 027 A (SPENKLIN LIMITED) * figures 1,2 *	1,3,4	B25B5/06
A	---	1,4	
A	GB 1 541 898 A (SPENKLIN LIMITED) * page 2, line 90 - line 97; figures 1,2 *	1,5	
A	---		
A	FR 2 044 137 A (ÉTABS DE MÉCANIQUE BRUNET & PRAMAGGIORE) * page 1, line 8 - line 23; figure 1 *	1	
A	---		
A	GB 1 152 159 A (LONDON TELESPHOR MORAWSKI ET AL) * the whole document *	2	
A	---		
A	GB 2 082 093 A (MASCHINENFABRIK HILMA GMBH) * page 2, line 98 - line 102; figure 1 *		
A	---		
A	DE 39 13 375 C (DE-STA-CO METALLERZEUGNISSE GMBH)		TECHNICAL FIELDS SEARCHED (Int'l Cls)
A	-----		B25B
A	EP 0 179 325 A (APPLIED POWER INC.)		
The present search report has been drawn up for all claims			
Place of search	Date of completion of the search	Examiner	
THE HAGUE	30 October 1997	Carmichael, Guy	
CATEGORY OF CITED DOCUMENTS			
X : particularly relevant if taken alone	T : theory or principle underlying the invention		
Y : particularly relevant if combined with another document of the same category	E : earlier patent document, but published on, or after the filing date		
A : technological background	D : document cited in the application		
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P : intermediate document	A : member of the same patent family, corresponding document		

Specification

[Title of the Invention] FIXTURE

[Abstract]

[Problem to be Solved] To provide a fixture having an excellent working efficiency and working property in product-clamping and clamp-releasing action, in which positioning a clamper, fastening the product and the reverse motions can be done consecutively with a single working tool without need of operating the clamper by hand and the clamper is fastened in a fixed location.

[Solution] A fastening screw (5) is inserted in the hollow section of a clamper (2), and a rubber pusher (3) with a friction rubber (4) is fitted on the fastening screw (5) from below and fixed to the fastening screw (5) in a little pressing relation against the clamper (2). Then, the cylindrical portion of the clamper (2) is inserted into the hollow section of a body (1), and a locating pin (6) of the clamper (2) for its rotational direction is mounted to the body (1).

[Claims]

[Claim 1]

A fixture having a configuration, in which:

(a) a fastening screw (5) is inserted into the hollow section of a clamper (2);

(b) a rubber pusher (3) with a friction rubber (4) is penetrated by the fastening screw (5), with the clamper (2) held between the rubber pusher and the head of the fastening screw (5), and fitted on the fastening screw in a pressing relation against the clamper (2);

(c) the cylindrical portion of the clamper (2) is inserted into the hollow section of a body (1); and

(d) a locating pin (6) is mounted to the body (1).

[Detailed Description of the Invention]

[0001]

[Field of the Invention]

This invention relates to a fixture for fixing a product in machine tool working.

[0002]

[Prior Art]

In machine tool working, a fixture has been in use which comprises a product-fixing clamper and a clamper-fastening screw provided on a locating jig to fix a product in position.

[0003]

[Problem to be Solved by the Invention]

Such a fixture has drawbacks as follows.

(a) When a product is fixed to a locating jig and when the product is removed from the locating jig, attachment/detachment of the clamper of the fixture is performed by hand, resulting in a poor working efficiency.

(b) When a product is fixed to a locating jig, the clamper of the fixture must be pressed down in a clamping location of the product while the fastening tool is held in one hand and the product is pressed down by the other hand, resulting in a poor working property.

This invention is intended to eliminate these drawbacks.

[0004]

[Means for Solving the Problem]

A fastening screw (5) is inserted in the hollow section of a clamper (2), a rubber pusher (3) with a friction rubber (4) is fitted on the fastening screw (5) from below, with the clamper (2) held between the friction rubber (4) and the head of the fastening screw (5), so that the rubber pusher (3) is mounted on the fastening screw (5) in a little pressing relation against the clamper. Then, the clamper (2), fastening screw (5) and rubber pusher (3) with the friction rubber (4) assembled in one body are inserted into the hollow section of a body (1) nicely fitting the cylindrical portion of the clamper (2), and

a locating pin (6) of the clamper (2) for its rotational movement is mounted to the body (1). This invention is directed to a fixture configured as described above.

[0005]

[Embodiment of the Invention]

Now, an embodiment of this invention will be described below.

(a) A fastening screw (5) is inserted in the hollow section of an L-shaped clamper (2) having a flat clamping plate protruded from its hollow shaft end.

(b) A friction rubber (4) is attached to a rubber pusher (3).

(c) The clamper (2) is held between the head of the fastening screw (5) inserted in the clamper (2) and the rubber face of the friction rubber (4) attached to the rubber pusher (3), and the rubber pusher (3) is mounted on the fastening screw (5) in a little pressing relation against the clamper (2).

(d) The clamper (2) incorporating the fastening screw (5), rubber pusher (3) and friction rubber (4) is inserted into the hollow section of a body (1) nicely fitting the cylindrical portion of the clamper (2).

(e) A locating pin (6) of the clamper (2) for its rotational movement is mounted to the body (1) so as to be fitted in a rotation-stopping groove of the clamper (2).

The fixture of this invention has the structure as described above. When the fixture is used, a screw for the fastening screw (5) of the fixture to be fitted in is formed in a locating jig (9), and the fixture is mounted on the locating jig (9) with fixture-mounting screws (11) such that the formed screw coincides with the fastening screw (5). A product (10) is positioned on the locating jig (9) to which is mounted the fixture, and the fastening screw (5) is turned, with a fastening screw-operating tool held in one hand. Although the clamper (2) is initially located out of the positioning range of the product (10), since the clamper (2) is held between the head of the fastening screw

(5) and the friction rubber (4) in a pressed relation, it begins rotational movement through the frictional force of the friction rubber (4) in association with the turning movement of the fastening screw (5) and stops its rotational movement after rotated to the position of the locating pin (6). When the clamper (2) is positioned by the locating pin (6) in the rotational direction, the fixture is mounted to the locating jig (9) such that it coincides with the clamping location of the product (10). When the fastening screw (5) is tightened further, the clamper (2) moves down to fasten the product (10) for fixing. When the clamper (2) is unfastened from the product (10) to release the state of fixing, if the fastening screw (5) is turned in the reverse direction to be loosened, the clamper (2) first rotates in the reverse direction to the position of the locating pin (6), moving out of the positioning range of the product (10), and stops its rotational movement. When the fastening screw (5) is loosened further, the clamper (2) is pushed up by the rubber pusher (3) fixed to the fastening screw (5), and separated from the product (10).

[0006]

#### [Effect of the Invention]

When the product is set on the locating jig, in spite of the clamper being set on the product by hand, if the fastening screw of the fixture is first tightened with a working tool, the clamper is rotated to a clamping position of the product in association with the rotation of the fastening screw, and adapted to move downward from that position to fix the product. In addition, when the state of fixing is released, the clamper is automatically removed from the product in association with the rotation of the fastening screw, resulting in an excellent working efficiency. Further, since the clamper need not be operated by hand, this make it possible that a tool is held in one hand and the product is supported securely by the other hand, resulting in an improved working property. Furthermore, the product is fastened in a constant location by means of the stopper

of the clamper, thereby providing a stable working accuracy of the product. As shown in Fig. 4, a structure may be adopted in which a pressure is exerted on the rubber pusher (3) by a spring (7), a pin key (8) is attached to the fastening screw (5), and rotation of the fastening screw (5) is transmitted to the rubber pusher (3) through the key (8).

[Brief Description of the Drawings]

Fig. 1 is a perspective view of a fixture of this invention.

Fig. 2 is a sectional side view of the fixture of this invention.

Fig. 3 is a sectional plan view of the fixture of this invention.

Fig. 4 is a sectional side view showing another embodiment of this invention.

Fig. 5 is a sectional side view of an example in which the fixture of this invention is used.

[Description of Reference Numerals]

1: body    2: clamper    3: rubber pusher    4: friction rubber  
5: fastening screw    6: locating pin    7: spring    8: key    9:  
locating jig    10: product    11: fixture-mounting screw

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